

Work Order ID 150682

Monday, August 29, 2016 3:00:12 PM

646.3015

P 150682

150682

Page 1

Item ID: 646.3015

P E V. N / C

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade

Start Date: 8/8/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date: AUG 30 2016

Tooling:

Date:

Run Start ***NR1***

QC:

9-89

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

646.3000

N/C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 6.580"

DAS

49

9-89

10 ϕ 16/10/28

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB150

DWG REV: N/C

FOLIO REV: AA

10 ϕ 16/10/30

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL
BURRS ON CUTTING EDGE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____		Work Order update only ☐																																															
Work Order: _____ Part No. _____ NCR No. _____		<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="2" style="text-align: center;">DISPOSITION</th> <th colspan="4" style="text-align: center;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="text-align: center;">Rework</td><td>☐</td> <td style="text-align: center;">Skid-tube</td><td>☐</td> <td style="text-align: center;">Cross tube</td><td>☐</td> <td style="text-align: center;">Water Jet</td><td>☐</td> <td style="text-align: center;">Engineering</td><td>☐</td> </tr> <tr> <td style="text-align: center;">Scrap</td><td>☐</td> <td style="text-align: center;">Machining</td><td>☐</td> <td style="text-align: center;">Small Fab</td><td>☐</td> <td style="text-align: center;">Prod. Eng. Coord.</td><td>☐</td> <td style="text-align: center;">Quality</td><td>☐</td> </tr> <tr> <td style="text-align: center;">Use-as-is</td><td>☐</td> <td style="text-align: center;">Thermoforming</td><td>☐</td> <td style="text-align: center;">Finishing</td><td>☐</td> <td style="text-align: center;">Rec/Store/Packaging</td><td>☐</td> <td style="text-align: center;">Other</td><td>☐</td> </tr> <tr> <td style="text-align: center;">Suspected Unapproved</td><td>☐</td> <td style="text-align: center;">Large Fab</td><td>☐</td> <td style="text-align: center;">Composite</td><td>☐</td> <td style="text-align: center;">Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		
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Page 2

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Blade

Start Date: 8/8/2016

Start Qty: 10.00

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Cust Item ID:

Required Date: 8/29/2016

Req'd Qty: 10.00

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

10 0 16/10/30

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

B = 16/11/01

10 0 DAS 08 9-89

140

Outsource process - Heat Treat

0.00

140

Outsource1

Memo

0.00

Outsource process - Heat Treat

HEAT TREAT AS PER DWG, SEE NOTE #3

ISSUE P/O: 34239

10 NOV 08 2016 DAS 13 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 3

Item ID: 646.3015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade

Start Date: 8/8/2016 Start Qty: 10.00 ***10***

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Spray Painting per QSI005 4.2	0.00							
160									
SprayPaint	Memo	0.00							
Spray Painting	PRIME AS PER DWG, SEE NOTE #4								
	PRIMER BATCH: <u>134100</u>								

10x 8/16-11-17.

10 DAS
38
9-89
NOV 18 201610 DAS
41
9-89
16-11-25

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC14- Inspect Spray Paint	0.00							
170									
QC	Memo	0.00				10			DAS 38 NOV 29 2016
Quality Control									
180	Identify as per dwg & Stock Location: <u>CC4103</u>	0.00							
180									
Packaging	Memo	0.00				10			DAS 6 NOV 29 2016
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							16/11/29 JF
Quality Control									

DAS
21
9-89

NOV 29 2016

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OTHER :																																																																							

Picklist Print

Monday, August 29, 2016 3:00:11 PM

Page 1

Work Order ID: 150682

150682

Parent Item: 646.3015

646 3015

Parent Item Name: Blade

Start Date: 8/8/2016

Required Date: 8/29/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 12/11/09 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased	No			100	f	6.7935	0.549	5.778947			

MSTFFI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

Location	Loc Qty	Loc Code
MAT	0.3125	
M134172	0.3125	
MAT010	6.481	
M126438	5.452	
M127494	0.22	
M131783	0.609	
M133923	0.2	

M135558 → 5.59

DAS
49
9-89

16/10/28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

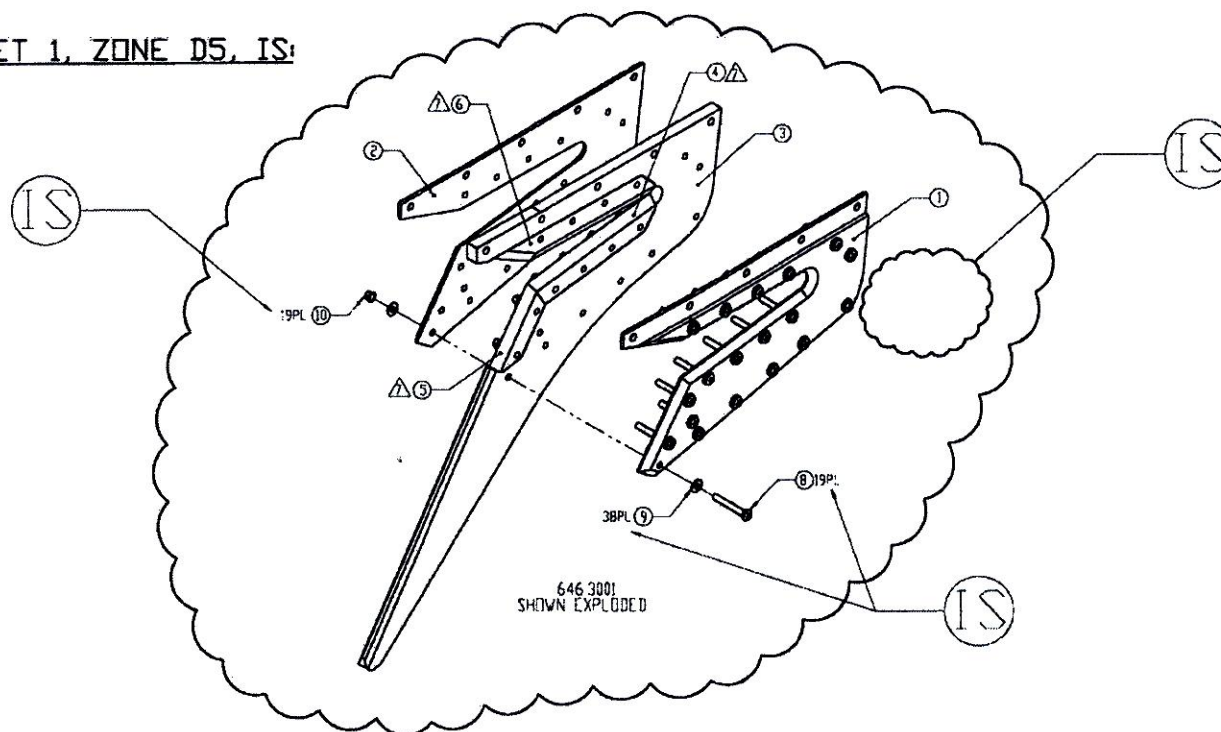
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause				FAULT CATEGORY																					
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐															
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐															
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Past Expiry Date ☐		Manufacturing Process ☐		OTHER :																					
Misidentified ☐		Past Due ☐																							

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02195		SHEET 1 OF 4	
	DWG NO. 646.3000	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09
	EFFECT ON DWG ☐ INC. ☒ UNINC.			
	DWG TITLE: LOWER CUTTER ASSY			
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS		

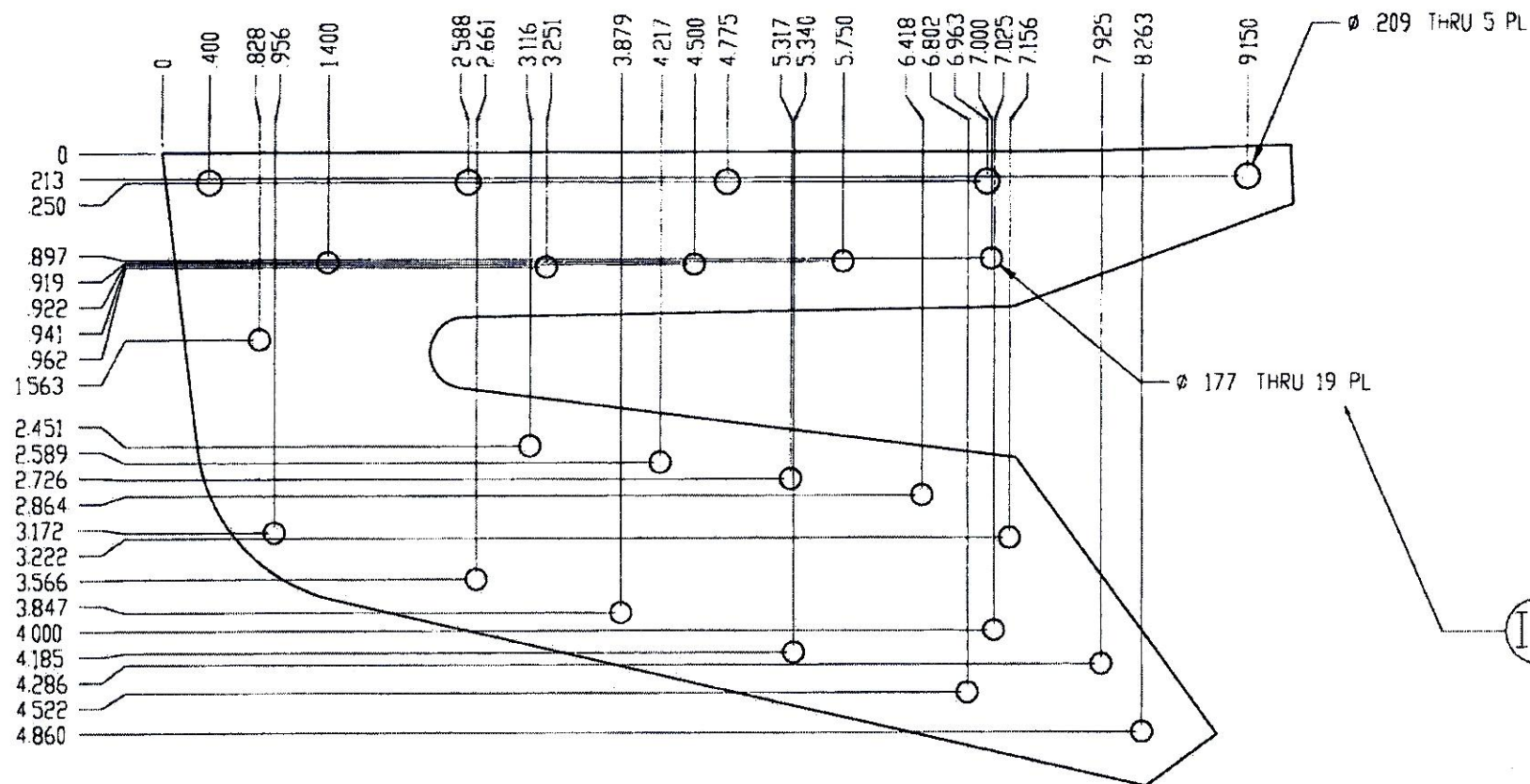
SHEET 1, ZONE D5, IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150682 MJS
1608-30

10	R	601.1541	19	LOCKNUT	MS21042L08
9	R	601.2764	38	WASHER	NAS1149FN832P
8	R	601.2765	19	SCREW	MS27039-0819
7	D	601.2766	2	RIVET	MS20470AD5-18
			.3001		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: ☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM					CHANGE CATEGORY ☐ MAJOR ☒ MINOR
					DER REVIEW REQUIRED ☐ YES ☒ NO

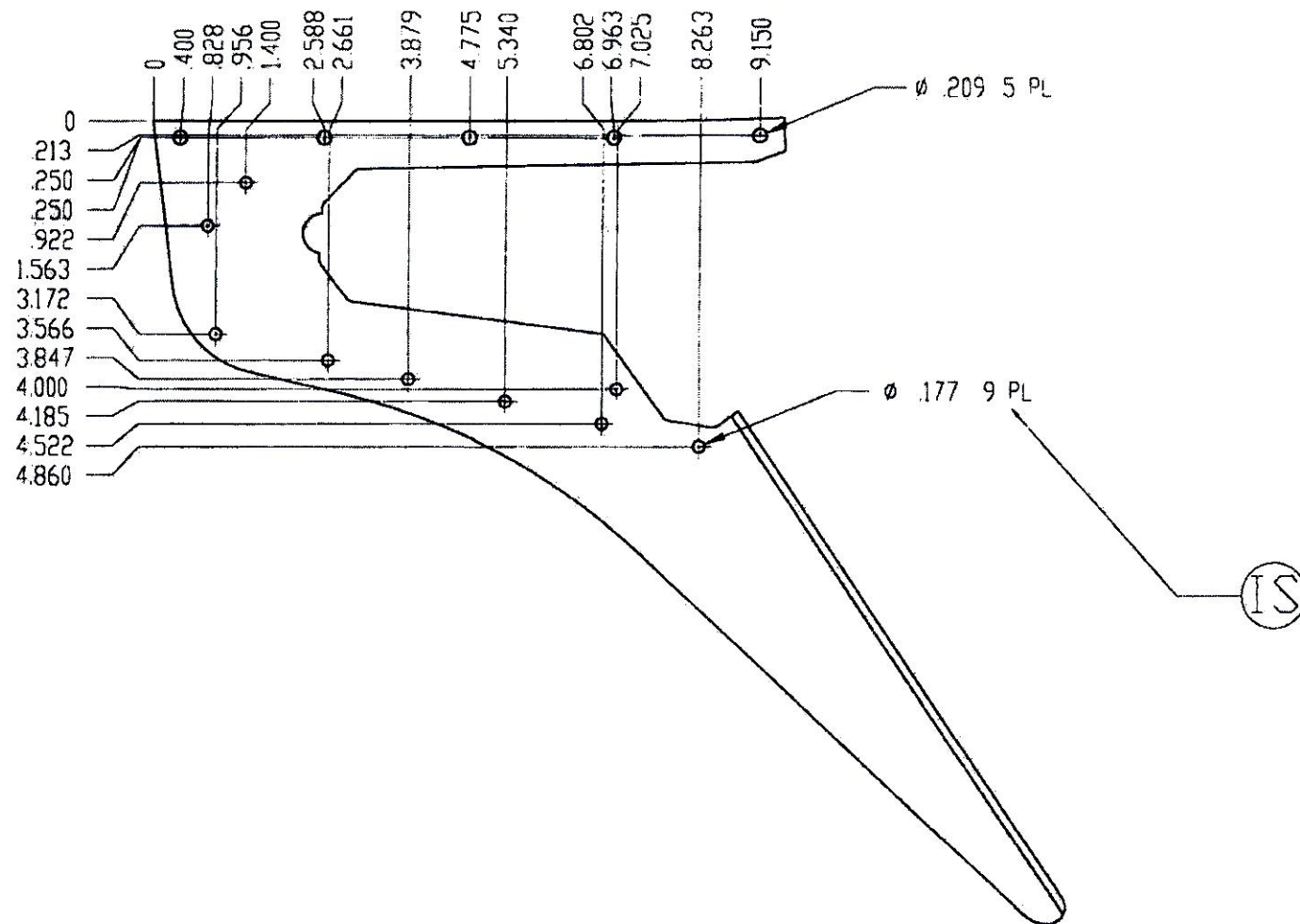
SHEET 3 IS:



SECTION A-A

2
C7

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

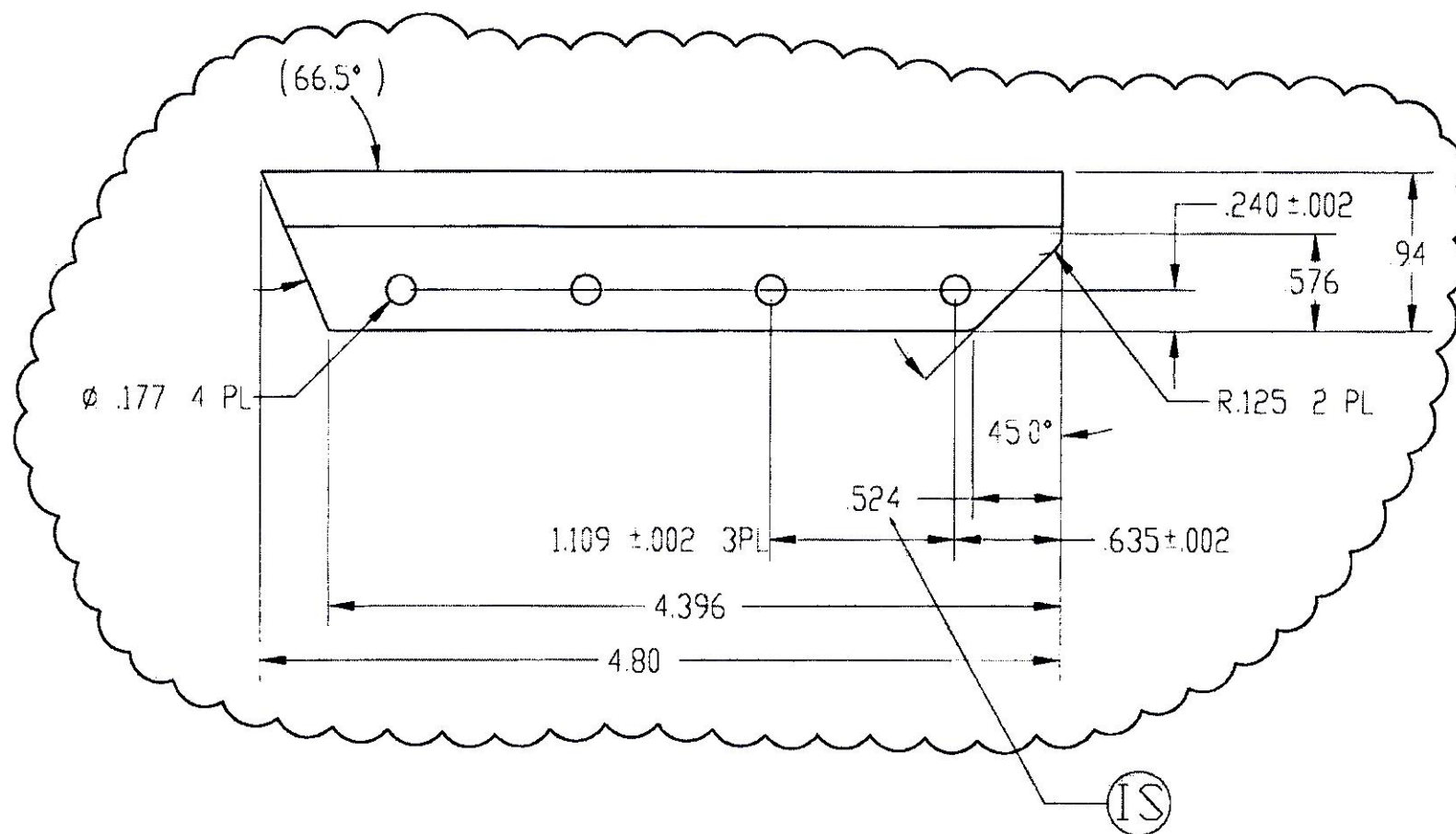
SHEET 5 IS:

SECTION F-F



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 6, ZONE C4, IS:

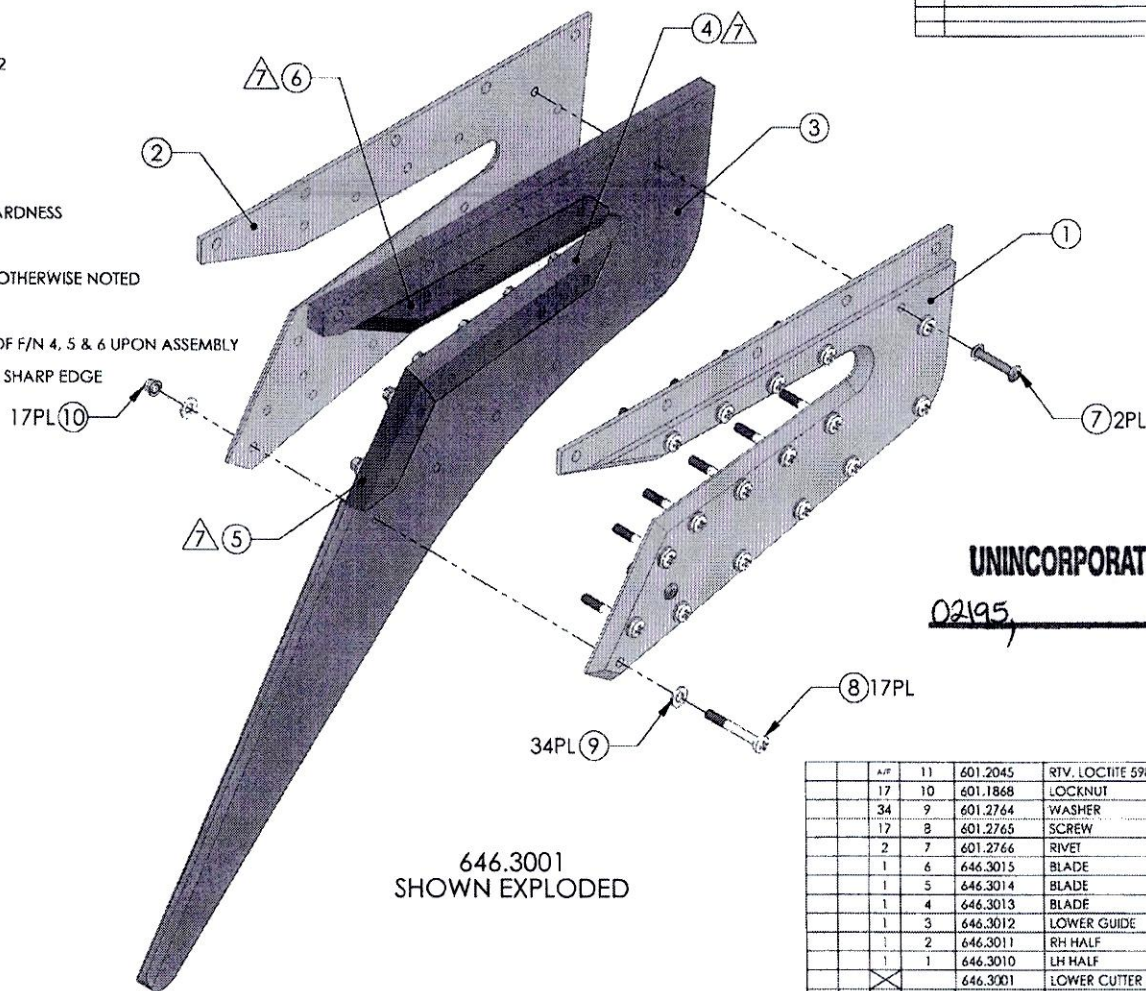


F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

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NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 11 AS REQUIRED TO ALL FAYING SURFACES OF F/N 4, 5 & 6 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE



646.3001
SHOWN EXPLODED

UNINCORPORATED ECN(s)

02195

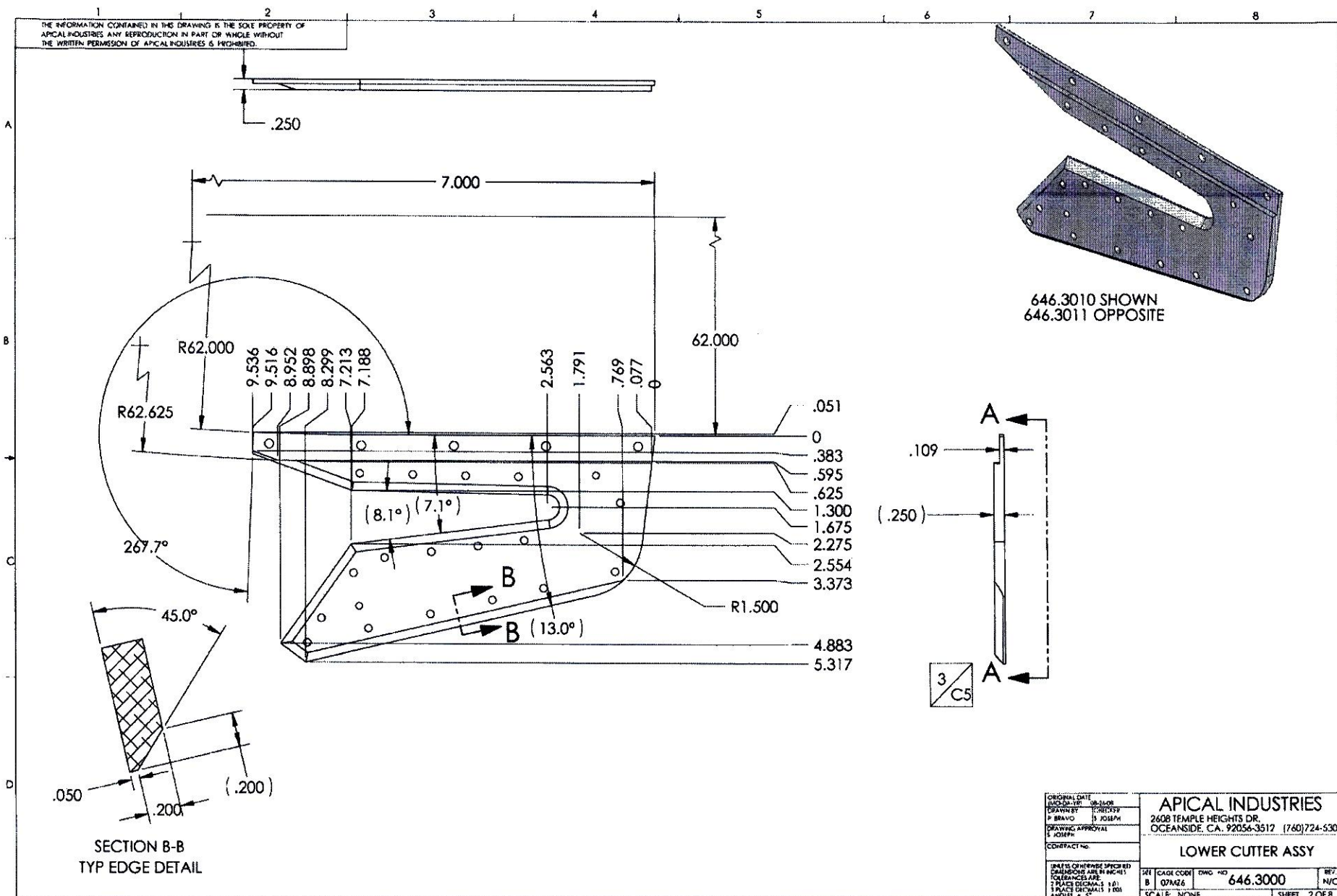
QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
1	11	601.2045	RTV, LOCITE 598		
17	10	601.1868	LOCKNUT	M12X1.5X3-OR	
34	9	601.2764	WASHER	M12X1.5X1.5X3-OR	
17	8	601.2765	SCREW	M12X1.5X3-OR	
2	7	601.2766	RIVET	M12X1.5X3-OR	
1	6	646.3015	BLADE		
1	5	646.3014	BLADE		
1	4	646.3013	BLADE		
1	3	646.3012	LOWER GUIDE		
1	2	646.3011	RH HALF		
1	1	646.3010	LH HALF		
1		646.3001	LOWER CUTTER ASSY		

QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
1		646.4000	LOWER CUTTER ASSY		

ORIGINAL DATE 10/10/01	DESIGNED BY P. REAVO	DATE 10/10/01
DRAWING APPROVAL P. REAVO	CHECKED BY S. JOHNSON	DATE 10/10/01
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES 2 PLACE DECIMALS 1/16 3 PLACE DECIMALS 1/32 ANGLES ± .5°		

APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300			
LOWER CUTTER ASSY			
REV B	CAGE CODE 07426	DWG NO 646.3000	REV N/C
SCALE NONE		SHEET 1 OF 8	

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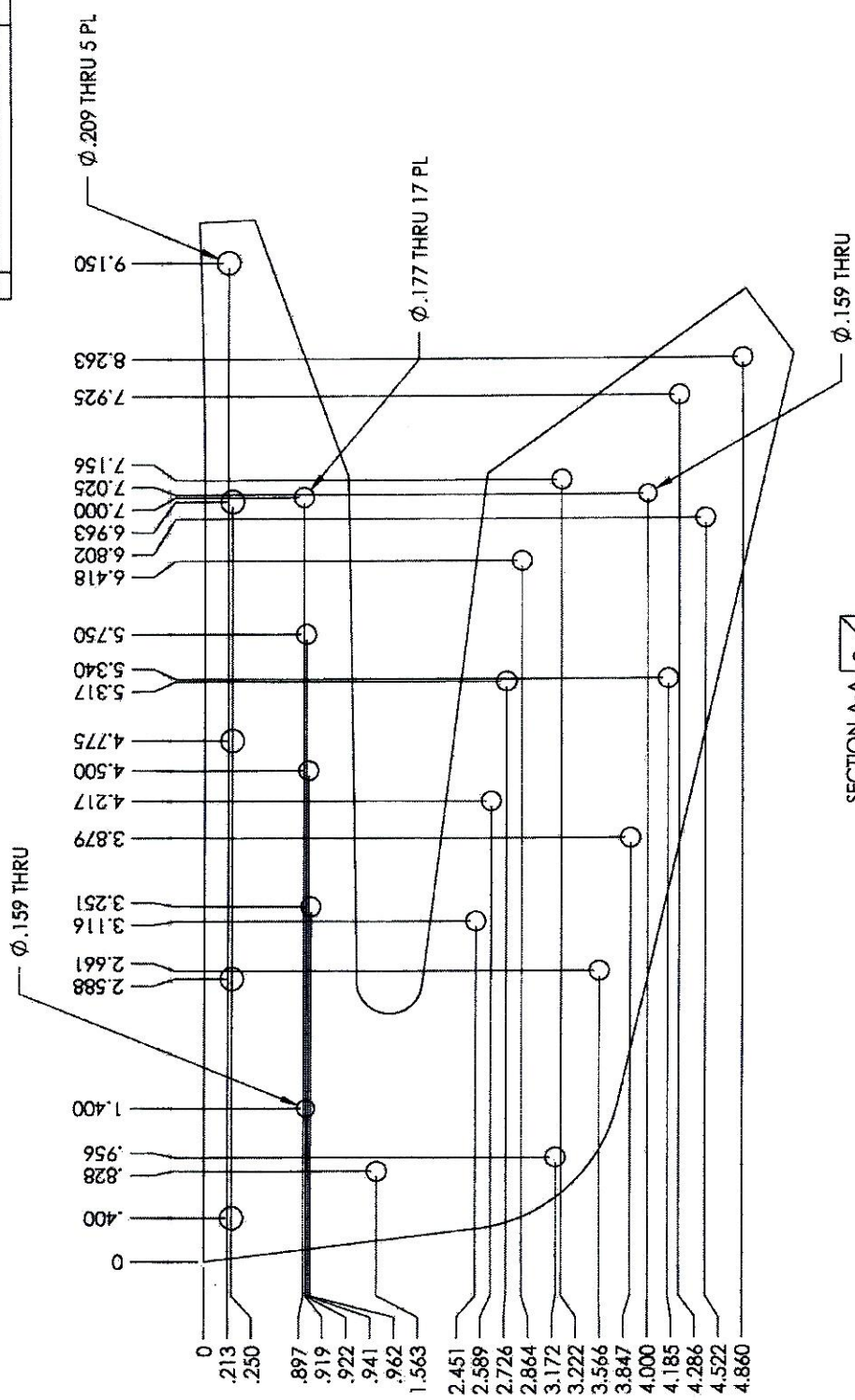


ORIGINAL DATE 10/24/10		APICAL INDUSTRIES	
DRAWN BY P. BRAVO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512	
DRAWING APPROVAL S. JOSEPH		(760) 724-5300	
CONTRACT NO.		LOWER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .001 ANGLES ± .5°		SEE CAGE CODE B 079426	REV. N/C
DWG. NO. 646.3000		SCALE: NONE	
SHEET 2 OF 8			

REV	DESCRIPTION	DATE	THROWING

1 2 3 4 5 6 7 8

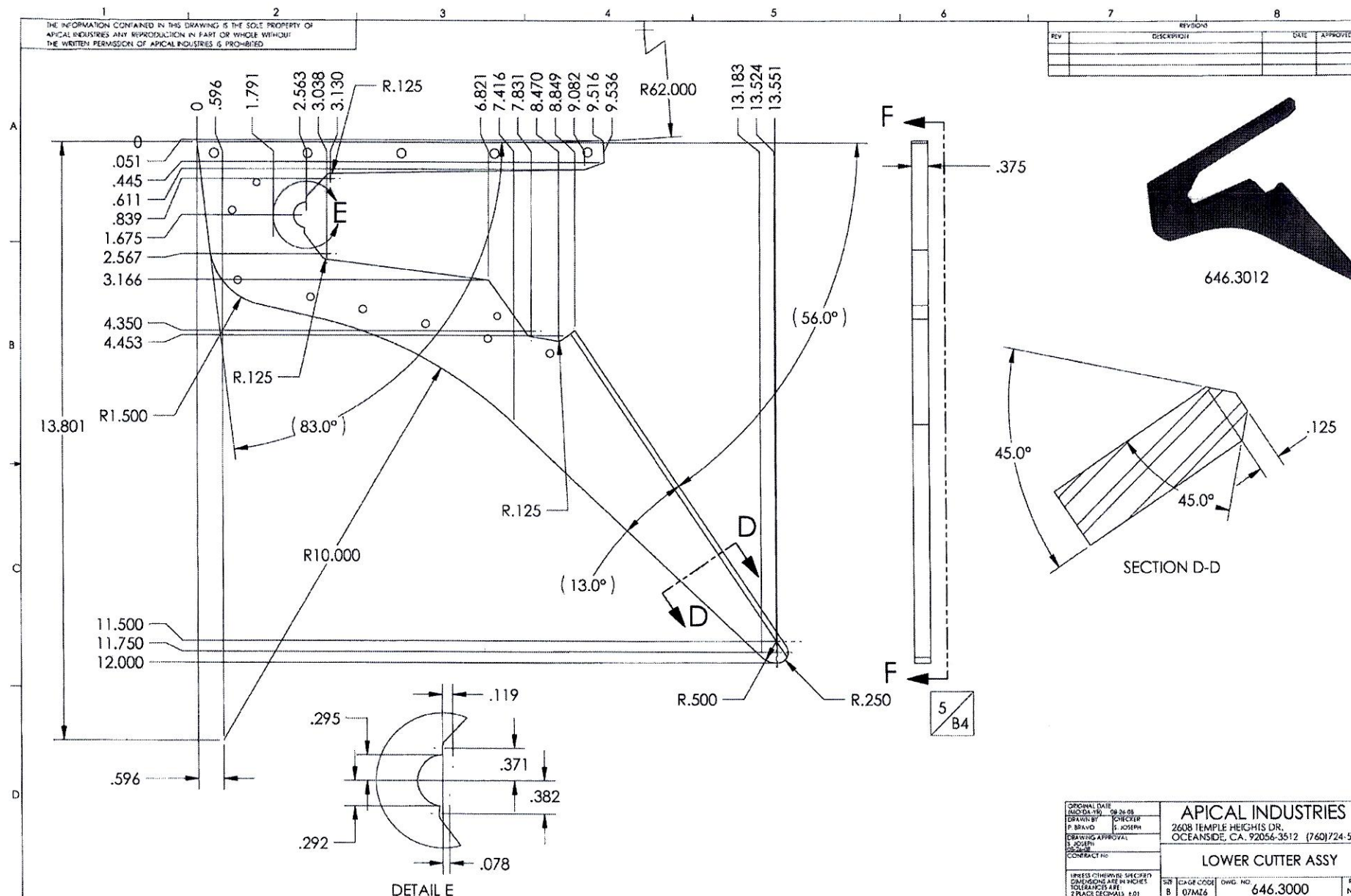
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



DESIGNED BY P. BRAY	CHECKED BY P. BRAY	DATE 11/11/11	PROJECT NO. 646.3000
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92066-5312 (760)724-5300		LOWER CUTTER ASSY	
SCALE: NONE		SHEET 3 OF 8	

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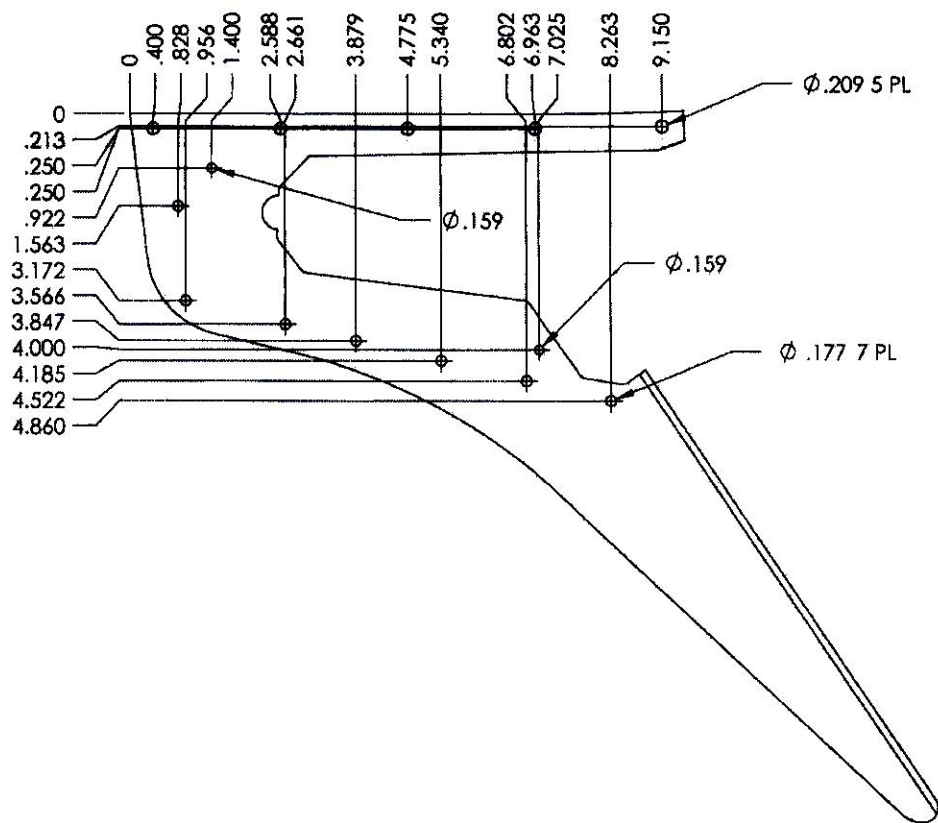
REVISION		DATE	APPROVED
REV	DESCRIPTION		



OPTIONAL DATE (M/D/YR) 08-26-08	APICAL INDUSTRIES		
DRAWN BY P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		
DRAWING APPROVAL S. JORDEN			
DATE 08-26-08			
CONTRACT NO.			
LOWER CUTTER ASSY			
PRESS CHISELS IN SHEETS DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1.3 PLACE DECIMALS 1.01 3.3 PLACE DECIMALS 1.000 ANGLES 1.5			
SIZ	CAGE CODE	QWSG. NO.	REV
B	07M76	646.3000	N/C
SCALE NONE		SHEET	4 OF 8

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

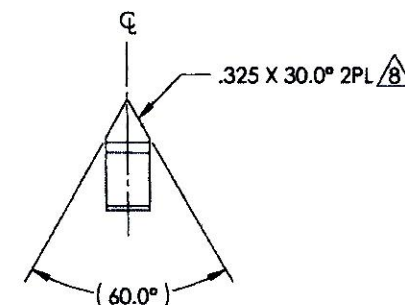
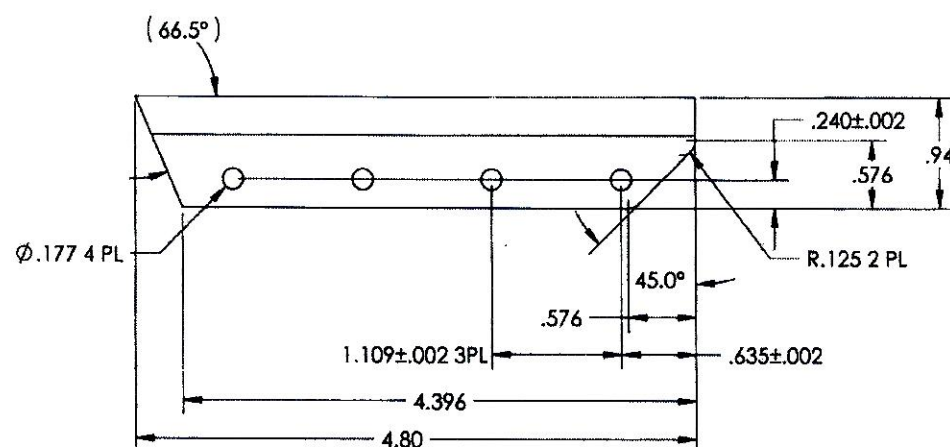
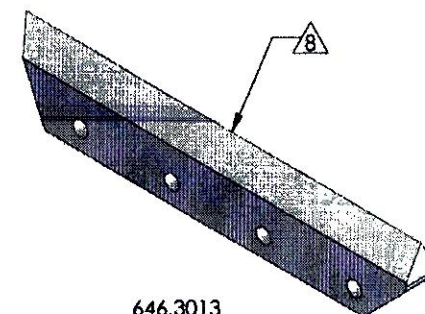
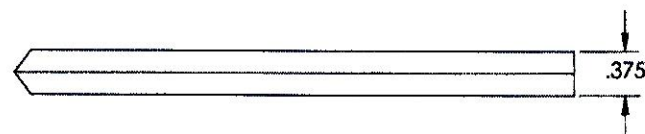


SECTION F-F 4
B6

ORIGINAL DATE INCHES: 1/8" (25.4 mm) DRAWN BY: P. BRAYO CHECKED BY: D. JOSEPH DATE: 10/10/00 CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		LOWER CUTTER ASSY	
REV	DATE	QTY	REV
1	07/02/00	646.3000	N/C
SCALE: NONE		SHEET 5 OF 8	

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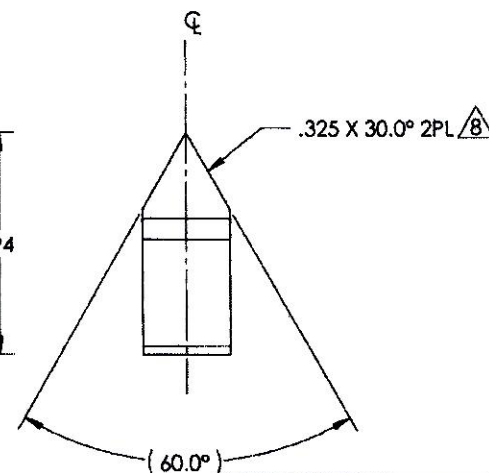
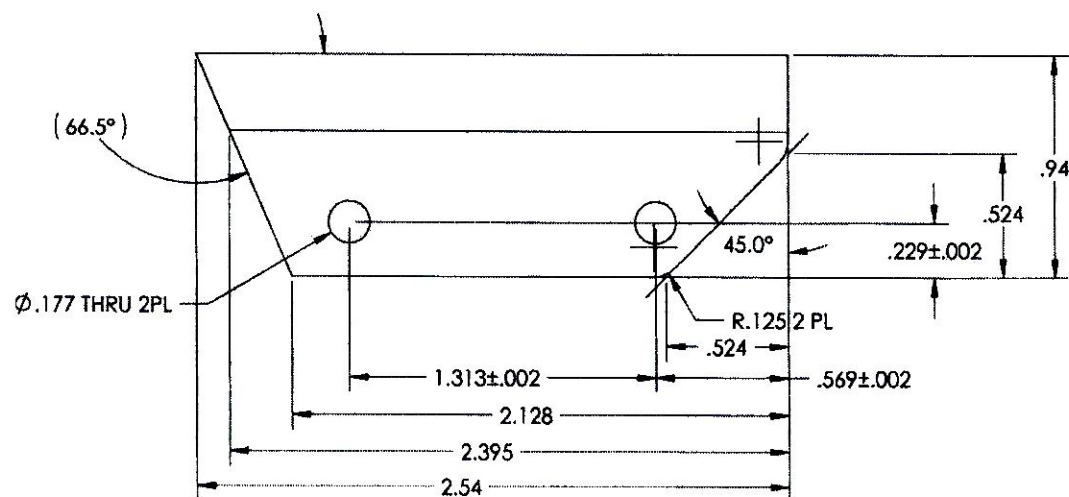
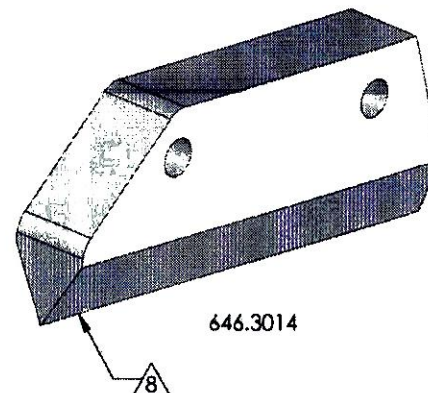
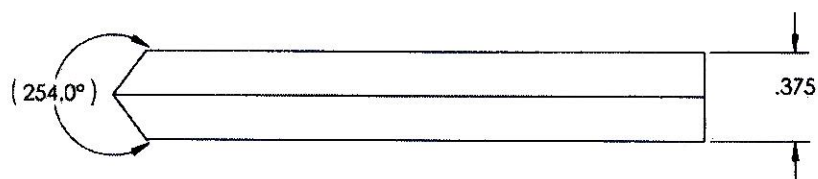
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE: 08-28-18		APICAL INDUSTRIES	
DESIGNED BY: J. BRAYO		2608 TEMPLE HEIGHTS DR.	
DRAWN BY: J. BRAYO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY: J. BRAYO		LOWER CUTTER ASSY	
APPROVED BY: J. BRAYO		SHEET 4 OF 8	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES FRACTIONS ARE 2 PLACE DECIMALS 1/32 3 PLACE DECIMALS 1/1000 ANGLES 1/4°		DATE: 07/24/24	REV: 646.3000
SCALE: NONE		N/C	

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REV	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE
 DESIGNED BY
 DRAWN BY
 P. BRAVO
 J. JOSEPH
 DRAWING APPROVAL
 J. JOSEPH
 CONTRACT NO.

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056 3512 1/801/24-5300

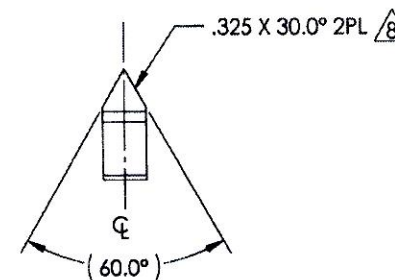
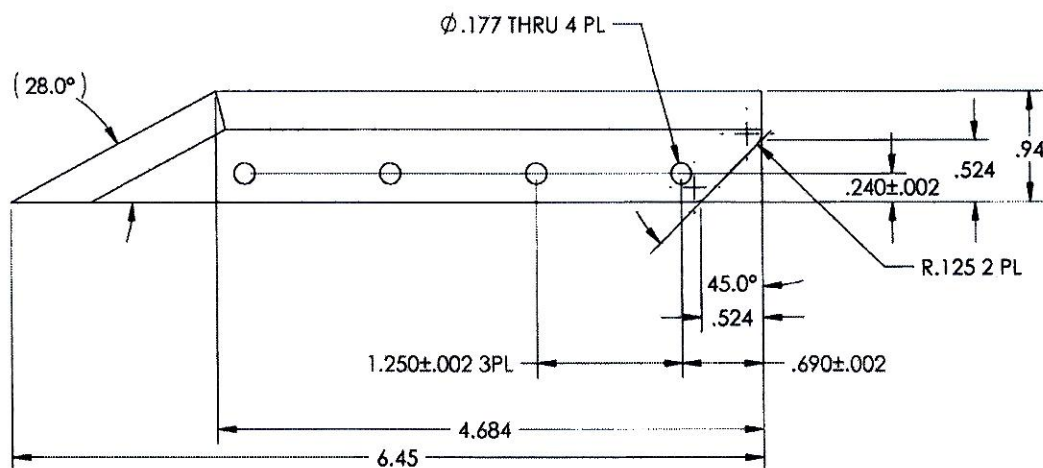
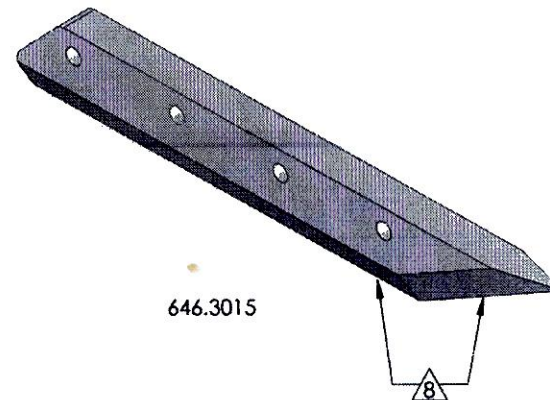
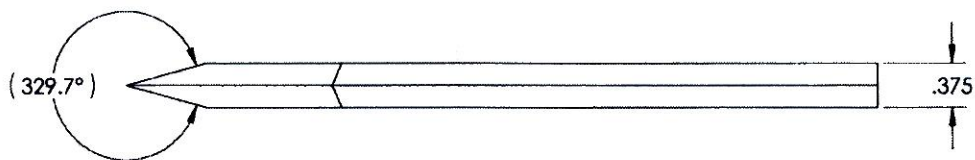
LOWER CUTTER ASSY

SIZE CAGE CODE DWG NO. 646.3000
 B D7MAG N/C

SCALE NONE SHEET 7 OF 8

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE: 08-31-98		APICAL INDUSTRIES	
DRAWN BY: E. PECKER		2608 TEMPLE HEIGHTS DR.	
P. BRAYO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: S. JOSEPH		LOWER CUTTER ASSY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED			
DIMENSIONS ARE IN INCHES			
TOLERANCES ARE:			
2 PLACE DECIMALS 1.00			
3 PLACE DECIMALS 1.000			
ANGLES: 1°			
SHEET	8 OF 8	SCALE	NONE



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34239**

Purchase Order Date 11/8/2016

PO Print Date 11/10/2016

Page Number 1 of 3

Order From :

VC-MET004

Ship To : DART AEROSPACE LTD

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone 450 473 1884

Ship To Contact

Ship To Phone

Ship Via: FedEx Economy collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						

1	150610	646.3013 BLADES	11/22/2016		10.00	\$8.60	\$86.00
			Yes				
			11/22/2016				

FINISH: HEAT TREAT TO 58-62 RC
ROCKWELL HARDNESS

PART ARE MADE FROM AISI A2 TOOL STEEL

PLEASE NOTE: DETAIL C OF C REQUIRED

Line Total: \$86.00

2	150682	646.3015 BLADES	11/22/2016		10.00	\$8.60	\$86.00
			Yes				
			11/22/2016				

FINISH: HEAT TREAT TO 58-62 RC
ROCKWELL HARDNESS

PART ARE MADE FROM AISI A2 TOOL STEEL

PLEASE NOTE: DETAIL C OF C REQUIRED

88/16-11-17

Note:

11/10/2016

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
315037	1	115393

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À / Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
34239		A2	2016/11/9	fed
QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight

40 646.3013 BLADES

(10) 646.3013 150610

(10) 646.3015 150682

(10) 646.3315 150696

(10) 646.3316 150642

14,

1 BOITE DE PLASTI

2016-11-17

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE PLASTI	1	

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 40

POIDS EXPÉDIÉ / Weight Shipped : 14,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 40

POIDS EXPÉDIÉ / Weight Shipped : 14,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2016/11/15

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
315037	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

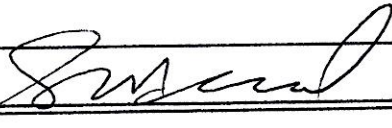
HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
34239	N/A	A2		
<u>SPECIFICATIONS DU PROCÉDÉ</u> processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results				
HARDNESS		58 - 62 HRC	5	60 - 62 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
40	14	646.3013 BLADES (10) 646.3013 150610 (10) 646.3015 150682 (10) 646.3315 150696 (10) 646.3316 150642 1 BOITE DE PLASTI		

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2016-11-15

15 nov

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
315037	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
34239	N/A	A2		
<u>SPÉCIFICATIONS DU PROCÉDÉ</u> processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	5	60 - 62 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
40	14	646.3013 BLADES (10) 646.3013 150610 (10) 646.3015 150682 (10) 646.3315 150696 (10) 646.3316 150642 1 BOITE DE PLASTI		

COMMENTAIRES / comments

VAC HARDEN 1750F, 1 HR
DOUBLE TEMPER 400F, 2 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles. À titre de précaution,

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité D tail 

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
315037	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVR    / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

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APPROUV  par / Approved by:

Isabel Otero
QA Technician

DATE: 2016-11-15

